

Work Order ID 79175

January-23-12 10:45:10 AM

79175

Page 1

Item ID: D4148-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Assembly, Fwd
 Start Date: 23/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	D								

100 0.00
100
 Small Fab Memo 0.00
 Small Fab 1- Assemble as per dwg
 SB 12/02/03
 (4)

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control
 S. 12/02/03
 (4)

120 Identify as per dwg & Stock Location: 468 0.00
120
 Packaging Memo 0.00
 Packaging
 12/2/4 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/06 

12-02-4
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-23-12 10:45:13 AM

Page 1

4

Work Order ID: 79175

79175

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,193.000

4

8

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

582

119901

582

ST301

539

118077

2

118614

441

118686

30

119758

66

MS21043-4

Purchased

No

100

Each

1,977.000

1

12

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

441

118686

441

ST301

1496

119546

496

120308

1000

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Page 2

Work Order ID: 79175

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Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2690-6 Manufactured No

100 Each

5.0000

1

4

D2690-6

Lanyard Assembly

**

Location

Loc Qty

Loc Code

ST016

5

78694

5

D3910-1 Manufactured No

100 Each

26.0000

1

4

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

st507

26

78326

26

D4091-1 Manufactured No

100 Each

11.0000

1

4

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST458

11

77320

11

D4148-1 Manufactured No

100 Each

31.0000

2

8

D4148-1

Crosstube Lug Plate, Fwd

**

Location

Loc Qty

Loc Code

ST132

31

78331

31

D4148-3 Manufactured No

100 Each

4.0000

1

4

D4148-3

Stud Receiver, Lower

**

Location

Loc Qty

Loc Code

ST133

4

78049

4

4 512/02/03

4 512/02/03

4 512/02/03

4 512/02/03

7 B 78048 512/02/03

4 512/02/03

January-23-12 10:45:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

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D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

D4148-5 Manufactured No

100 Each

11.0000

1

4

D4148-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST133

11

78330

11

AN3C12A

Purchased No

100 Each

40.0000

2

8

AN3C12A

Bolts

**

Location

Loc Qty

Loc Code

ST351

40

117514

4

118112

5

118422

8

118451

22

119510

1

AN4C13A

Purchased No

100 Each

39.0000

3

12

AN4C13A

BOLT

**

Location

Loc Qty

Loc Code

ST357

39

120187

39

MS17984-C413

Purchased No

100 Each

8.0000

1

4

MS17984-C413

PIN, QUICK RELEASE

**

Location

Loc Qty

Loc Code

ST315

8

114340

1

118612

2

120123

5

Ep 12/02/03

Ep 12/02/03

M120423 (8x)

Ep 12/02/03

M120423 (1x)

Ep 12/02/03

M120521 (4x)

January-23-12 10:45:13 AM

Shop Packet Print

Page 3

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Page 4

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D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS20615-4M18 Purchased No

100 Each

407.0000 8 32

MS20615-4M18

Rivet

**

EP 12/02/03

Location

Loc Qty

Loc Code

ST323

407

118077

243

118543

164

32

NAS1149C0332R Purchased No

100 Each

2,486.000 4 16

NAS1149C0332R

Washer

**

EP 12/02/03

Location

Loc Qty

Loc Code

ST297

2486

118354

705

119736

1781

16

NAS1149C0432R Purchased No

100 Each

3,388.000 6 24

NAS1149C0432R

Washer

**

EP 12/02/03

Location

Loc Qty

Loc Code

ST297

3388

117291

2388

119124

1000

24

January-23-12 10:45:13 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

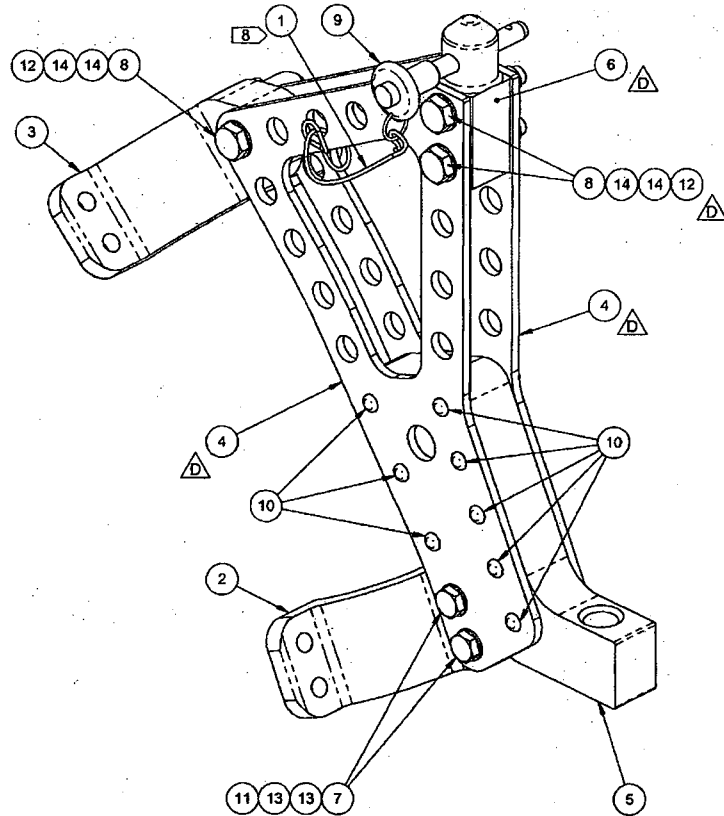
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4148-041 FWD X-TUBE LUG ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

UNCONTROLLED
SUBJECT
NO 79175 H.C.J
12/01/23

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.250" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
 - 7) WEIGHT: 3.67 lbs
 - 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D4148
REV. D
SHEET 1 OF 5
TITLE FWD X-TUBE LUG ASSY
SCALE NTS
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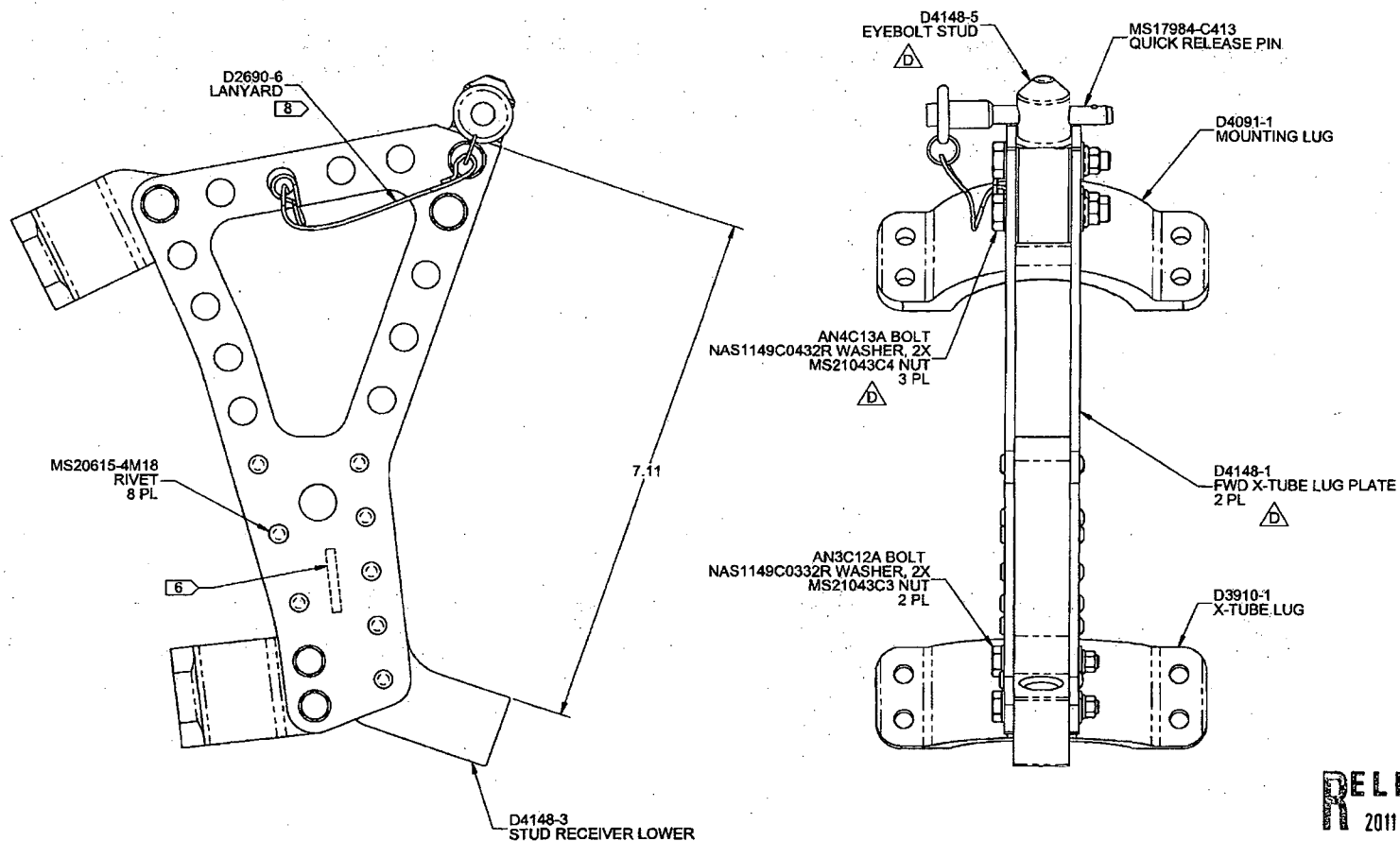
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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79175



D4148-041 FWD X-TUBE LUG ASSY

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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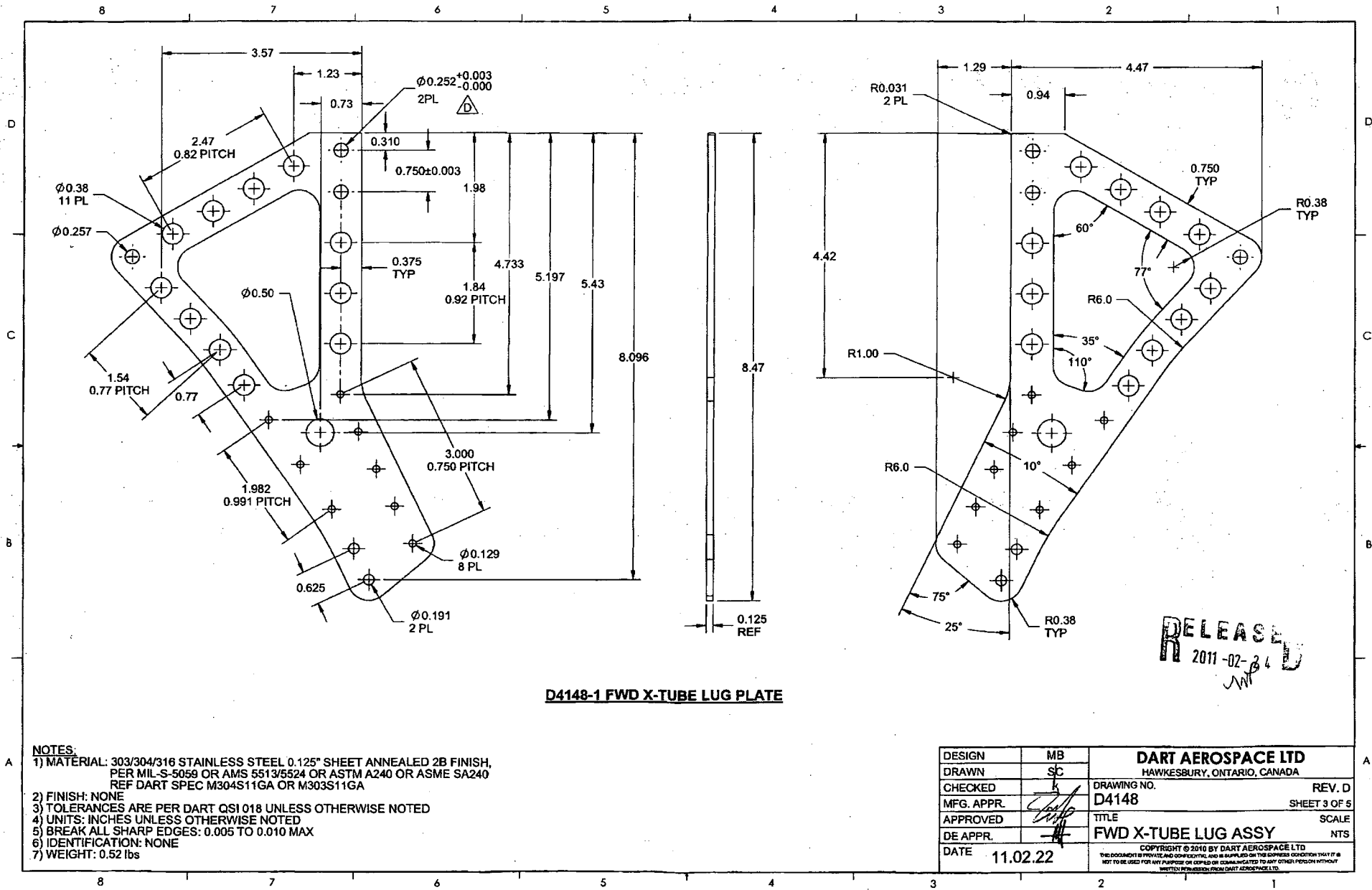
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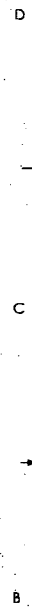
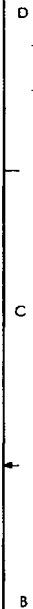
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NOTE: Date & initial all entries

A horizontal number line with 8 points labeled 1 through 8 from right to left. The line is divided into 7 equal segments by vertical tick marks.



B

A

DESIGN	MB,	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4148 TITLE FWD X-TUBE LUG ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR DISTRIBUTED WITHOUT THE WRITTEN PERMISSION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR ON COMMERCE TO ANY OTHER PERSON WITHOUT REFERRING TO DART AEROSPACE LTD.	REV. D
DRAWN	SC		SHEET 4 OF 5
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.02.22		

A

A horizontal number line with tick marks at every integer from 1 to 8. The numbers 1, 2, 3, 4, 5, 6, 7, and 8 are labeled below the corresponding tick marks. The segment of the line between the tick marks for 4 and 5 is shaded gray.

W/O:		WORK ORDER CHANGES					
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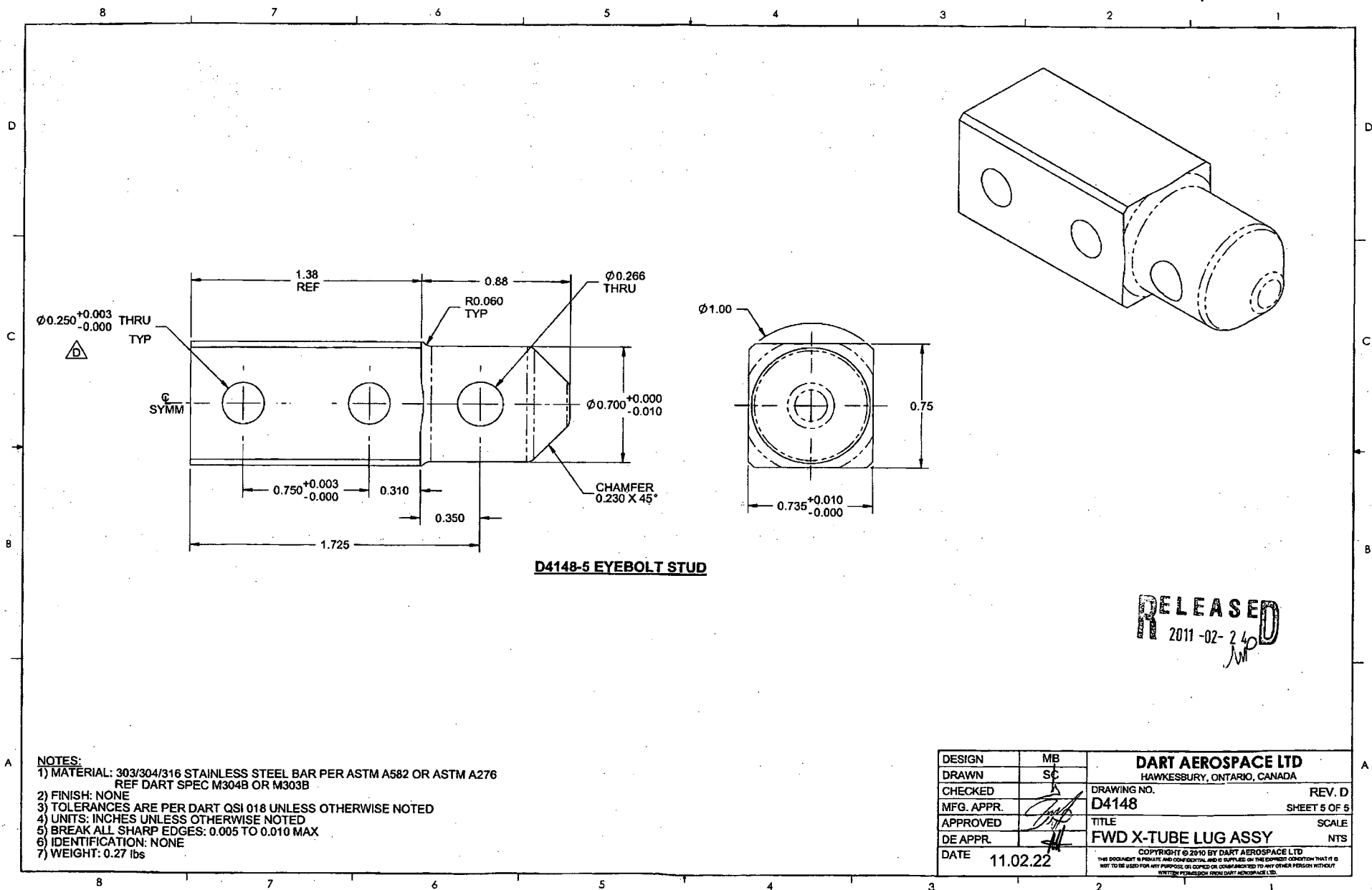
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RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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